

APPLICATION

FOR

UNITED STATES OF AMERICA

SPECIFICATION

TO ALL WHOM IT MAY CONCERN:

Be it known that We,

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and

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have invented certain improvements in

“CONTAINER WITH INHERENTLY STABLE BASE MADE OF
FLEXIBLE MATERIAL AND METHOD FOR MANUFACTURING IT”

of which the following description in connection with the accompanying drawings is a specification, like reference characters on the drawings indicating like parts in the several figures.

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Cross-Reference To Related Applications

This application claims priority to Italian Application No. PD99A000216 filed October 5, 1999, the disclosure of which is incorporated herein by reference.

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The present invention relates to a container with an inherently stable,
5 self-shaping base which is made of flexible material and to a method for
manufacturing it.

These pouches, manufactured according to the state of the art, are poorly suited for containing liquids, granular products or powders which do not have a definite geometry of their own, so that the resulting containers are not inherently stable and cannot all be arranged in the same manner in the packages for transport and storage and in the points of sale and display.

20 This type of container entails a more expensive manufacturing process,
and the material from which it is obtained also is more expensive.

25 SUMMARY OF THE INVENTION

An object is to provide a container which after filling is inherently stable,
30 i.e., forms a very specific resting base.

Another object is to provide a method for manufacturing a container with an inherently stable base made of flexible material which allows fast and low-cost manufacture.

The present invention also relates to a method for manufacturing an inherently stable container made of flexible material, characterized in that it comprises the following steps:

b) heat-sealing in the sides of the pouch, in the region of the transverse
25 heat-seal, two triangles, each of which has a base which coincides with one
of the two edges of the pouch and a vertex which wedges toward the inside
of said pouch;

30 d) folding and bonding, with an adhesive means, the wings that form

adjacent to the base simultaneously with the heat-sealing of the upper open mouth.

BRIEF DESCRIPTION OF THE DRAWINGS

Further characteristics and advantages of the invention will become better apparent from the detailed description of a preferred embodiment and of a method for performing it, which are given by way of non-limitative example and are illustrated in the accompanying drawings, wherein:

Figure 1 is a schematic view of a line for manufacturing the container according to the invention;

10 Figures 1a, 1b and 1c are three schematic side views of what is shown in Figure 1;

Figure 2 is a view of alternative steps of the manufacture of the container according to the invention;

Figures 2a, 2b and 3c are three side views of what is shown in Figure 2;

15 Figure 3 is a view of the container before the lower wings are folded;

Figure 4 is a view of the container with its wings folded and with its upper mouth heat-sealed.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

With reference to the figures, the container according to the invention is obtained starting from a sheet 10 made of heat-sealable plastic material which is unwound from a roll 11 and is heat-sealed along a longitudinal line 12 after folding said sheet.

In a subsequent step, shaped bars 13 kept at a temperature which allows the melting of the sheet 10 provide, in the region that will correspond to the base region of the container 14 being formed, lateral triangles 15 and a heat-sealed transverse region 16 which closes the base of the container.

Simultaneously with the heat-sealing of the base through the heat-sealed region 16, the upper mouth of the container 17 that has already been formed and filled, is closed by way of a transverse heat-seal 18, while separation of said container is achieved by means of a cropping operation 19 which

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Owing to the presence of the heat-sealed triangles 15, the weight of the introduced material determines the formation of a flat base 20 produced by the wedging of the heat-sealed triangles 15 with the optional aid of ribbed guides 21 which are formed in the same operation that forms the heat-sealed triangles 15.

10 These two wings, in a final operation, as shown in Figure 4, are folded
against the container and are retained by heat-sealing or by applying an
10 adhesive means along the mating line 24.

Folding and gluing of the wings 22 and 23 occurs, as shown in Figure 2, with the aid of a shaped body 25 which has a heated seat 26 which duplicates the final shape of the base to be obtained, which forms due to the effect of the weight.

Said auxiliary means are constituted by insertion blades 28 and 29 which, by rotating about two axes 30 and 31 which are parallel to the advancement line of the container, push the triangles, now designated by the reference numerals 32 and 33, inside the container 27.

In Figure 2, dashed lines show the two blades 28 and 29 also in a plan view, in which they are illustrated in two positions: an outer one, designated by the reference numerals 28a and 29a, and an inner one, designated by the reference numerals 28b and 29b, which illustrate the insertion of the

The resulting container is highly advantageous, since by being formed from a flexible sheet it has all the characteristics and advantages of this type of container related to the manufacturing processes and to the printing thereon of designs and lettering.

Furthermore, the containers can be prepared empty and kept flat for storage until they are filled; during filling they assume their final shape by forming the flat base.

It is of course possible to use, as source materials, several known types of heat-sealable flexible material.

The disclosures in Italian Patent Application No. PD99A000216 from which this application claims priority are incorporated herein by reference.